

Date: Wednesday, 21/01/2009 7:37:51 AM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LEVER ARM  
 Job Number : 44978  
 Estimate Number : 12069  
 P.O. Number :  
 This Issue : 21/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : SMALL /MED FAB  
 Previous Run : 43093  
 Part Number : PB6743001261  
 Drawing Number : B6743001 PAGE39  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 27/01/2009 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 09-01-21  
 Comment : Est. A 05.06.07 New issue KJ/JLM  
 Est Rev:B 08-06-23 now made on water jet DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .250 x 6.00



OUT OF MATERIAL



Comment: Qty.: 1.4574 f(s)/Unit Total : 29.1480 f(s)  
 6061-T6 Bar .25" x 6.0" 109025 1B 9-2-5

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001

Dwg Rev: B1

Prog Rev: B1

1B 9-2-5

2-Deburr if necessary

1B 9-2-5

M-L

09/02/06

16x

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1B 9-2-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 9-2-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/01/2009 7:37:51 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEVER ARM

Job Number: 44978

Part Number: PB6743001261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat

(Ref: 4.3.5 ) as per QSI 005 4.3

M 102316

(16)

START TIME:

10:45

OVEN TEMPERATURE:

320°

FINISH TIME:

11:15

BR 09-02-10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS

09/02/10 X16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST437

SS

09/02/10 (X16)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11 JF

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>W4978</u>
<b>Description:</b> Lever Arm		<b>Part Number:</b> B67-43001-261
<b>Inspection Dwg:</b> B67-43001 Pg39 <b>Rev:</b> B1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.005/-0.001	0.251	✓			
Ø0.38	+0.006/-0.001	0.38	✓			
Ø0.50	+0.006/-0.001	0.502	✓			
Ø1.00	+0.010/-0.001	1.00	✓			
1.00	+/-0.030	1.000	✓			
2.00	+/-0.030	2.008	✓			
3.00	+/-0.030	3.001	✓			
12.25	+/-0.030	12.25	✓			
18.63	+/-0.030	18.625	✓			
1.75	+/-0.030	1.753	✓			
2.13	+/-0.030	2.133	✓			
16.25	+/-0.030	16.25	✓			
22.00	+/-0.030	22.00	✓			
1.75	+/-0.030	1.751	✓			
3.38	+/-0.030	3.381	✓			
4.88	+/-0.030	4.882	✓			
6.50	+/-0.030	6.501	✓			
8.13	+/-0.030	8.133	✓			
9.88	+/-0.030	9.890	✓			
33.29	+/-0.030	33.29	✓			
0.25	+/-0.030	0.248	✓			

<b>Measured by:</b> <u>HB</u>	<b>Audited by:</b> <u>S. Orla</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <u>9-7-5</u>	<b>Date:</b> <u>08/07/25</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue	KJ/DD	<u>[Signature]</u>

